



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3130-55-119

Job Sheet 201351



Part No: RBW109-3130-55-119

Job Qty: 1 pcs **2 ALL**

Part Name: Support Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/19

Job Tracking No:

Due Date: 11/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 19-978 DWG RBW109-3130-55-119 Rev 4 IPP Rev. A 19.09.30 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	11/20/19		0.00	0.20	Small Fab - 1		ALL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	1 pcs	11/20/19		0.00	0.00	QC 5 - 10		19-1128
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	Packaging 3-1 - Stock - B4B	1 pcs	11/20/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S235585



Part: RBW109-3130-55-119

Job No: 201351

Serial No/Batch: S235585

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 11/20/19

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130 QC 21 - FG	1 pcs	11/20/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21 NOV 2 8 7/19
				QC 21 - SA - 53	9-08

Part Op 100 - Assemble as per DWG.

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - Identify as per dwg & Stock Location: _____

130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98381A471	Dowel Pin	8 4 Ea (4 ea)	100-Small Fab - 1	5047617
RBW109-3130-55-119-1	Base	2 1 pcs (1 ea)	100-Small Fab - 1	52226411
RBW109-3130-55-119-3	Rod	8 4 pcs (4 ea)	100-Small Fab - 1	5226855

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	98381A471	4	96	0
	RBW109-3130-55-119-1	1	5	0
	RBW109-3130-55-119-3	4	20	0

Part Specifications

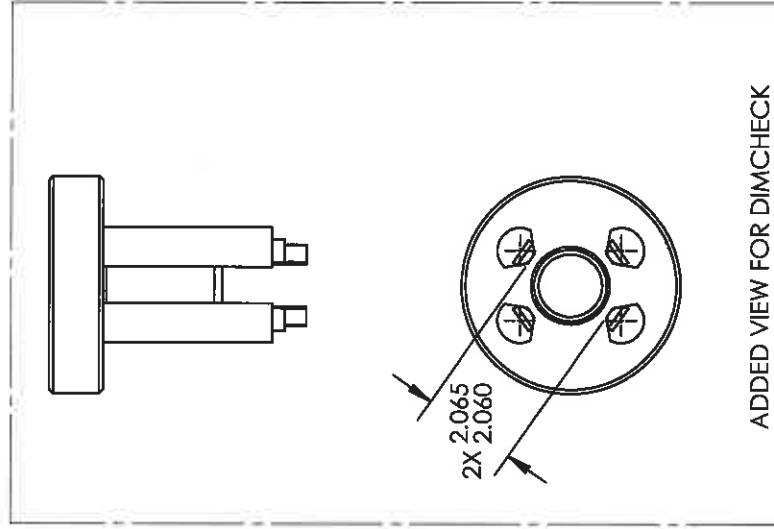
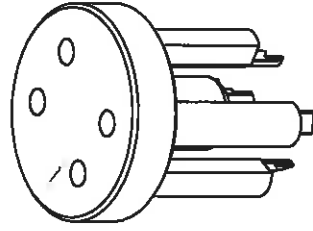
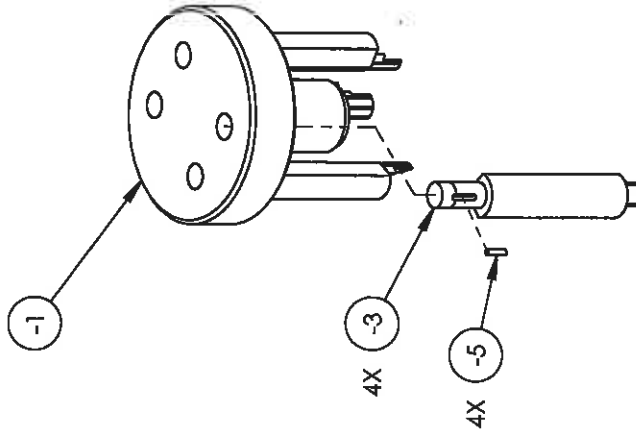
Specifications could not be found.

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REVISIONS

REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	BROKE OUT OF KIT RBW109-3130-55-117 -1 CHD ENGRAVE NOTE WAS ENGRAVE T/N "RBW109-3130-55-117" S/N "MADE IN USA" IS ENGRAVE T/N S/N "MADE IN USA". DELETED ENGRAVE NOTE: ENGRAVE P/N "1-123". -3 DELETED ENGRAVE NOTE WAS ENGRAVE P/N "1-121". ADDED NOTE "CENTER PERMITTED". ADDED CUT-EXTRUDE Ø561-562 X .375 FOR CLEARANCE.	6/26/2013	BIM	DW
3	CORRECTED CHECK DIM. -1 CHD POSITION ON LOCATION PINS. ADDED B.C. Ø2.664. -3 REVERSED HEIGHTS ON STEP. ADDED FLAT ON INSIDE. CHD THICKNESS ON STEPS, CHD Ø FROM 1.000 TO .985.	4/8/2014	JAG	GE
4	-1 DELETED COUNTERBORE ON HOLES. -3 CHD TOLERANCE ON DIM WAS .30 IS .300 +.0025 -.0000.	5/7/2014	DPD	GE



ADDED VIEW FOR DIMCHECK

NOTES:
1. REF. AGUSTA T/N:109-3130-55-125.
2. PART OF KIT: RBW109-3130-55-117.

RED BARN MACHINE

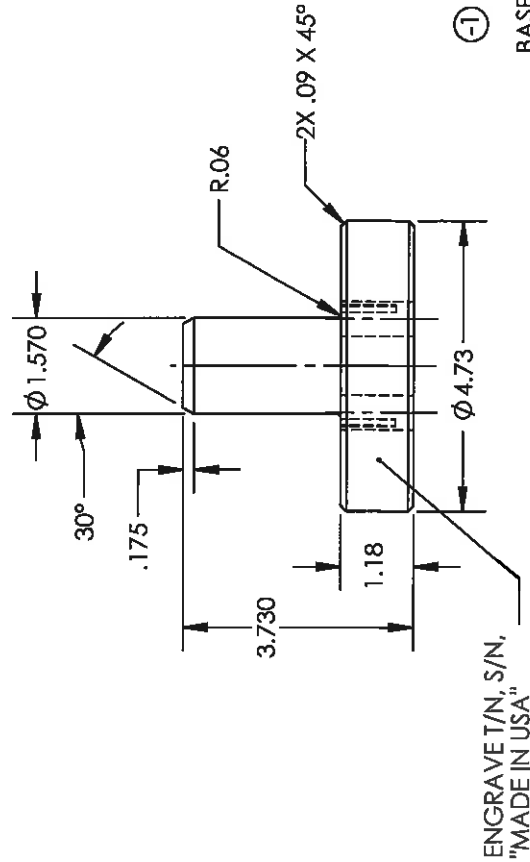
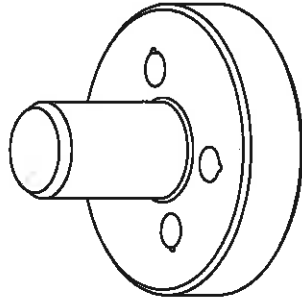
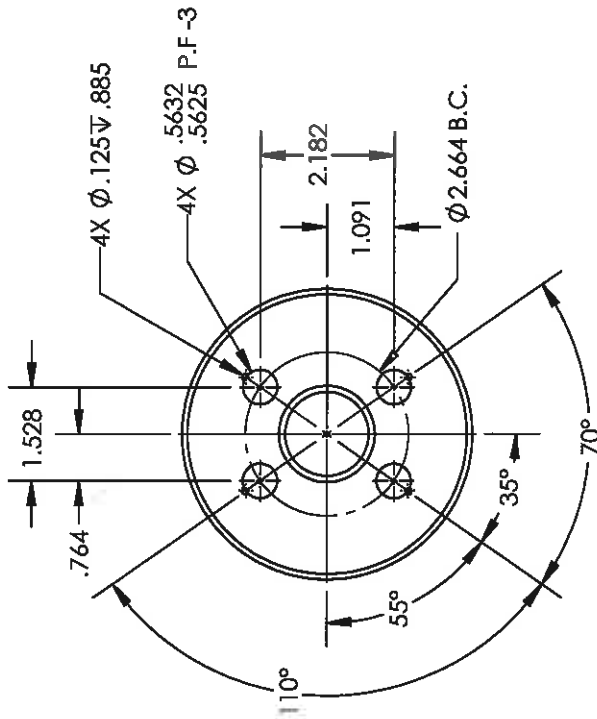
TITLE				SUPPORT ASSY		REV 4	
DWG NO.				RBW109-3130-55-119		REV 4	
MATERIAL				DRAWN BY: GILBERT		APPROVED: D. WEL	
UNLESS OTHERWISE SPECIFIED				DIMENSIONS ARE IN INCHES		HEAT TREAT	
.XXX ± .006				FRACTIONS ± 1/32		FINISH	
.XX ± .01				ANGLES ± 5°		SPEC	
.X ± .1				1. BREAK ALL SHARP EDGES .016 x 45°		USED ON MODEL	
OR .016R				2. DIMENSIONAL LIMITS APPLY AFTER PLATING		AW109	
SCALE				1:4		DATE 4/1/2011	
SHEET 1 OF 3							

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	6061	Ø4-3/4 X 3-3/4	2
			-3	4	ROD	4140 Q & T	Ø1 X 5-3/4	3
		B/O	-5	4	DOWEL PIN	STEEL	1/8 X 1/2 MCMASTER-CARR #98381A471	1

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REVISIONS

REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHD ENGRAVE NOTE WAS ENGRAVE T/N "RBW109-3130-55-119" S/N, "MADE IN USA", IS ENGRAVE T/N, S/N, "MADE IN USA", DELETED ENGRAVE NOTE: ENGRAVE P/N "123"	6/26/2013	BWA	DW
2	CHD POSITION ON LOCATION PINS, ADDED B.C. Ø2.664.	4/9/2014	JAG	GE
3	DELETED COUNTERBORE ON HOLES.	5/7/2014	DPD	GE



ENGRAVE T/N, S/N,
"MADE IN USA"

RED BARN MACHINE

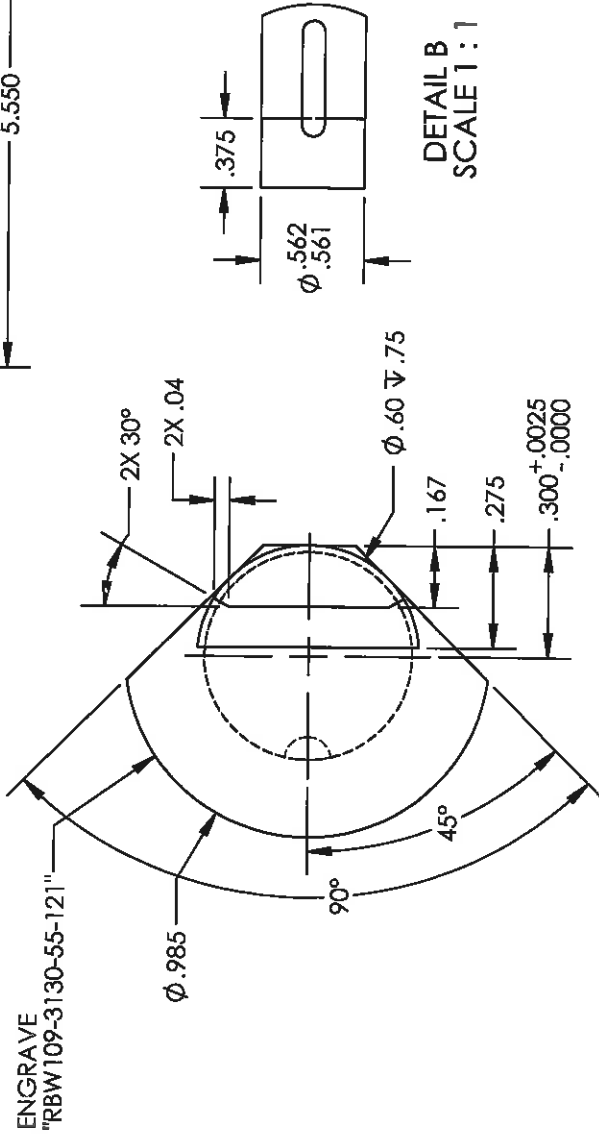
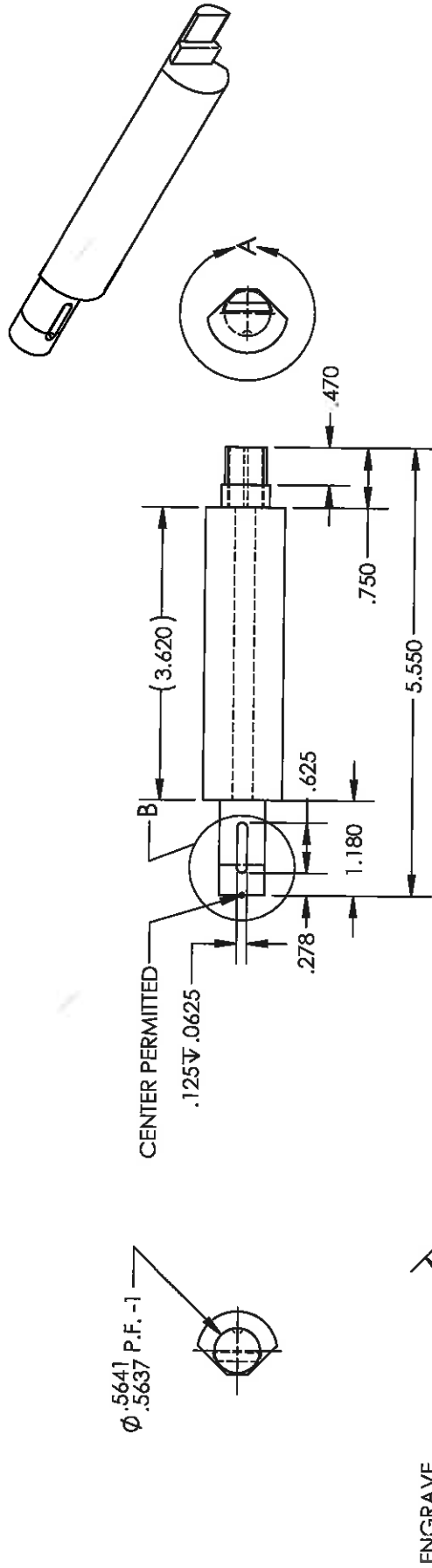
SUPPORT ASSY

DWG NO.	RBW109-3130-55-119-1	REV	4
MAT'L	6061	DRAWN BY:	GILBERT
UNLESS OTHERWISE SPECIFIED	APPROVED	DATE	3/31/2011
DIMENSIONS ARE IN INCHES	FINISH	USED ON MODEL	AW109
.XXX ± .005	HEAT TREAT	SCALE	1:3
.XX ± .01	FINISH	DATE	3/31/2011
.X ± .1	FINISH	SHEET 2 OF 3	
1. BREAK ALL SHARP EDGES .015 ± .005	FINISH		
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	FINISH		

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REVISIONS

REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	-3 DELETED ENGRAVE NOTE WAS ENGRAVE P/N "121". ADDED NOTE "CENTER PERMITTED". ADDED CUT-EXTRUDE Ø561-.562 X .375 FOR CLEARANCE.	6/12/2013	BIM	GE
3	-3 REVERSED HEIGHTS ON STEP, ADDED FLAT ON INSIDE, CHD THICKNESS ON STEPS, CHD Ø FROM 1.000 TO .985.	4/9/2014	JAG	GE
4	-3 CHD TOLERANCE ON DIM WAS .30 IS .300 +.0025 -.0000.	5/7/2014	DPD	GE



RED BARN MACHINE

SUPPORT ASSY

DWG NO. RBW109-3130-55-119-3 REV 4

DRAWN BY: GILBERT	DATE: 4/1/2011	SHEET 3 OF 3
APPROVED: <i>D. Med</i>		
UNLESS OTHERWISE SPECIFIED		
DIMENSIONS ARE IN INCHES		
FRACTIONS ± 1/32		
DECIMALS ± .01		
ANGLES ± .5°		
CAD PLATE YELLOW		
SPEC QQ-P-418F, TYPE II, CLASS II		
USED ON MODEL		
AW109		

DETAIL A
SCALE 2:1

DETAIL B
SCALE 1:1

ROD